



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3213-041
Job Sheet 170439



Part No: D3213-041

Job Qty: 4 ea

Part Name: Replacement Interior Door For -015 & -025



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 1/31/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV B IPP Rev:A New Issue 05-11-17 17:27

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		1/30/18	0.00	0.00	Start Up Small Fab-1		
100	Small Fab	4 pcs		1/30/18	0.00	1.56	Small Fab-3		
110	QC	4 pcs		1/30/18	0.00	0.00	QC5		
120	Powdercoat	4 pcs		1/30/18	0.00	0.27	Powdercoat4		
130	QC	4 pcs		1/30/18	0.00	0.00	QC3		
140	Small Fab	4 pcs		1/31/18	0.00	1.56	Small Fab-3		
150	QC	4 pcs		1/31/18	0.00	0.00	QC5		
160	Packaging	4 pcs		1/31/18	0.00	0.00	Packaging3-1		
170	QC21-SA	4 Ea		1/31/18	0.00	0.00	QC21		

Part Op 100 - 1-Assemble as per Dwg D3213 Transfer drill hinge using DT8470 & DT9520 Identify as D3213-041
Descriptions: 120 - START TIME 10:40 ONT 8:20 FINISH: 11:10 M138700.
140 - Assemble as per Dwg D3213

FEB 12 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D3161-3 F163809	8	10	0	0
	D3213-1 F163848	4	4	0	0
	D3213-3 F123332	4	9	0	0
	MS20470AD4-6	4	1,116	0	0
140-Small Fab	D2137 S023230	4	20	0	0
	D2419 F160690	4	11	0	0
	D2462 F115832	10	260	0	0
	D2728-1	4	0	0	0
	MS20470AD4-4 S027554	96	4,237	0	0
	NAS1149DN632J S024482	4	511	0	0

Part Specifications

Specifications could not be found.

Plex 1/16/18 12:47 PM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description W _____	DISPOSITION Rework ☐ Scrap ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Cross tube ☐	Water Jet ☐	Engineering ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Composite ☐	Supplier ☐	
Cross tube ☐	Water Jet ☐	Engineering ☐														
Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐														
Finishing ☐	Rec/Store/Packaging ☐	Other ☐														
Composite ☐	Supplier ☐															
		MRB (QSI042) Approval _____														
		Completed By _____														
		Lead hand / Supervisor Approval Verification _____														
		QC / QA Coordinator Approval _____														

Job No: 170439
 Start up Operation 02/01/18

Change No: _____
 Operation: _____
 Revision: _____
 Original Serial #: S038050
 PART NO: D3213-041

Replacement Interior Door For - 015 & - 025

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DART AEROSPACE
 S038050

Root Cause						
Environment ☐	No Re-vl ☐	Bending ☐	Broken/Damage/Detect ☐	Wrong Stock Pulled ☐	Positioned Wrong ☐	ss/Surge gram
Design ☐	Operator ☐	Centre Not Concentric ☐	Inspection Incomplete/Unqualified ☐	Out of Sequence ☐	Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Cracks ☐	Contamination ☐	Off-set ☐	Over/Under tolerance ☐	
Equip/Tooling ☐	Supplier ☐	Crimp/Kink/Ripple/Wave ☐	Countersink ☐	Mislabeled ☐	Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Cuffs ☐	Cut Too Short ☐	Fit/Function ☐	Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Crushing ☐	Instructions Incomplete/Unclear ☐	Misaligned/off center ☐	Part Moved ☐	
Internal Transport ☐	Poor Information ☐	Heat Treat ☐	Drill Holes ☐		Drawing ☐	
Tribal Knowledge ☐	Rushing ☐	Wave/Twist in Tube ☐			Finish ☐	
LOA ☐	Product Improvement ☐	Marks/Chatter ☐			Misread ☐	
Substation ☐	Process Improvement ☐				Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				
Misidentified ☐	Past Due ☐					